



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D4272-011
Job Sheet 183383



Part No: D4272-011

Job Qty: 1 ea

Part Name: Basket Assembly, Heavy Duty Lid, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A 11.01.20 AS PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Stores/Pkg-1		ML
100	Packaging	1 pcs	10/5/18	10/5/18	0.00	0.00	Packaging1-5		
110	HandFinish	1 pcs	10/5/18	10/5/18	0.00	2.94	HandFinish4		DAS
120	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC5		OCT 19 2018 68
130	Packaging	1 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		OCT 19 2018
140	QC21-SA	1 Ea	10/5/18	10/5/18	0.00	0.00	QC21		OCT 19 2018

Part Op 110 - TRANSFER DRILL FROM PLACARD INTO BASKET AS PER DWG ON SHEET 2 RIVET PLACARD AS PER DWG
Descriptions: ON SHEET 2

Job BOM

005779

Part / Item	Component Name	Quantity	Operation	Container
97447A010	Blind Rivet	4 pcs (4 ea)	90-Start up Operation	5019014
AN3-10A	Bolt	3 Ea (3 ea)	90-Start up Operation	5089298-1
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068652
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5089276
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5082704-1
AN310C4	Nut	3 Ea (3 ea)	90-Start up Operation	5065268
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5074206
AN4-13A	Bolt	6 Ea (6 ea)	90-Start up Operation	5089302
AN4C15	BOLT	1 Ea (1 ea)	90-Start up Operation	5053946
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068640
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5109659
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5097106
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5115452
D2690-6	Lanyard	2 Ea (2 ea)	90-Start up Operation	5094840
D2931	Bumper	2 Ea (2 ea)	90-Start up Operation	F86432
D3912-041	Eyebolt Receiver Assembly	1 Ea (1 ea)	90-Start up Operation	5104876
D3914-041	Long Basket Lid Assembly (350)	1 Ea (1 ea)	90-Start up Operation	5112386
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5115446
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5072726
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5068381
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5068380
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5117579

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5097232
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5115399
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5089207
D4021-5	Blanking Plate	1 Ea (1 ea)	90-Start up Operation	5072828
D4150-041	Attachment Arm Assembly	1 Ea (1 ea)	90-Start up Operation	5111288
D4151-041	Basket Fwd Hardpoint Assembly, Lower	1 Ea (1 ea)	90-Start up Operation	x 5104907
D4151-043	Basket Fwd Hardpoint Assembly, Upper	1 Ea (1 ea)	90-Start up Operation	x 5096991
D4273-041	Basket Base Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5111560
D4307-250	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	5072292
MS17984-C413	Quick Release Pin	2 pcs (2 ea)	90-Start up Operation	5108830
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	90-Start up Operation	5076007
MS21042L3	Nut	9 Ea (9 ea)	90-Start up Operation	5094592
MS21042L4	Nut	6 Ea (6 ea)	90-Start up Operation	5067899
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5083541
MS24665-151	Cotter Pin	4 Ea (4 ea)	90-Start up Operation	5053951-1
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5044180-1
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5050052-1
NAS1149C0463R	Washer	3 Ea (3 ea)	90-Start up Operation	FM127306-15
NAS1149DN832J	Washer	2 Ea (2 ea)	90-Start up Operation	5034411-1
NAS1149F0332P	Washer	14 Ea (14 ea)	90-Start up Operation	5103666
NAS1149F0432P	Washer	18 Ea (18 ea)	90-Start up Operation	5083558
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	5067901-2
NAS1515H4L	Washer	2 Ea (2 ea)	90-Start up Operation	5044189

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97447A010	4	714	0
	AN3-10A	3	301	0
	AN3-14A	4	100	0
	AN3-16A	2	118	0
	AN310-4	3	115	0
	AN310C4	3	143	0
	AN4-12	3	73	0
	AN4-13A	6	898	0
	AN4C15	1	19	0
	AN5-17A	4	102	0
	D2530	1	18	0
	D2535	2	44	0
	D2537	2	12	0
	D2690-6	2	39	0
	D2931	2	958	0
	D3912-041	1	6	0
	D3914-041	1	2	0
	D3917-3	6	21	0
	D3953-17	2	21	0
	D3953-19	1	26	0
	D3953-21	1	10	0
	D3953-3	2	4	0
	D3953-7	2	20	0
	D3953-9	2	7	0
	D3969-3	1	18	0
	D4021-5	1	46	0
	D4150-041	1	7	0
	D4151-041	1	6	0
	D4151-043	1	3	0
	D4273-041	1	0	0
	D4307-250	1	4	0
	MS17984-C413	2	46	0
	MS20600-AD4W3	2	357	0
	MS21042L3	9	3,308	0
	MS21042L4	6	4,182	0
	MS21042L5	4	888	0
	MS24665-151	4	252	0
	MS24665-300	2	128	0
	NAS1149C0432R	2	2,733	0
	NAS1149C0463R	3	335	0
	NAS1149DN832J	2	1,313	0
	NAS1149F0332P	14	3,621	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Container No: S119863



Part: D4272 - 011

Job No: 183383

Serial No/Batch: S119863

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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www.dartaerospace.com

Date: 10/19/16

NAS1149F0432P
NAS1149F0563P
NAS1515H4L

18
4
2

1,567
960
215

0
0
0

Part Specifications

Specifications could not be found.

Plex 9/17/18 11:05 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								